



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D066-1016-115
Job Sheet 180702



004787

Part No: D066-1016-115

Job Qty: 1 ea

Part Name: R66 Heli-Utility-Basket™ fixed provisions, full



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/12/18

Job Tracking No:

Due Date: 8/15/18

Created By: Marie Lajeunesse

Type: ~~SOLD~~ *slu*

Description:

Note: DWG REV B IPP REV:A 16.01.14 NEW ISSUE DD VERF:JLM IPP REV:B 17.03.28 as per iin rev.b DD
VERF:RQ

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup	Run	Workcenter / Supplier			
					hrs	Hrs				
90	Start up Operation	1 Ea	8/15/18	8/15/18	0.00	0.00	Start Up Stores/Pkg-2			AUG 01 2018
110	Packaging	1 pcs	8/15/18	8/15/18	0.00	0.00	Packaging1			AUG 01 2018
120	QC	1 pcs	8/15/18	8/15/18	0.00	0.00	QC4			9-09
130	Packaging	1 pcs	8/15/18	8/15/18	0.00	0.00	Packaging3-1			9-09
135	DC	1 pcs	8/15/18	8/15/18	0.00	0.00	DC			9-09
140	QC21-FG	1 Ea	8/15/18	8/15/18	0.00	0.00	QC21			9-09

Part Op 130 - Identify and pack for shipping as per PPP D066-1016-115 Location:
Descriptions: 135 - Photocopy bluefile & type labels per PPP D066-1016-115 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-12A	Bolt	8 Ea (8 ea)	90-Start up Operation	5079111
D5350-041	Fwd Cross Beam Assembly	1 Ea (1 ea)	90-Start up Operation	5066638
D5350-043	Aft Beam Assembly	1 Ea (1 ea)	90-Start up Operation	5093585
D5352-1	Cushion	4 Ea (4 ea)	90-Start up Operation	5159892
D5354-041	R66 Fwd Clamp Assembly, LH	1 Ea (1 ea)	90-Start up Operation	5063108
D5354-042	R66 Fwd Clamp Assembly, RH	1 Ea (1 ea)	90-Start up Operation	5063265
D5355-041	Aft Clamp Assembly	2 Ea (2 ea)	90-Start up Operation	5097230
D5358-1	Cover Plate	2 Ea (2 ea)	90-Start up Operation	5016585
D5445-041	Longitudinal Beam Assembly, LH	1 Ea (1 ea)	90-Start up Operation	5107065
D5445-042	Longitudinal Beam Assembly, RH	1 Ea (1 ea)	90-Start up Operation	5064271
MS20392-4C57	Pin	4 Ea (4 ea)	90-Start up Operation	5058142
MS24665-229	Cotter Pin	4 Ea (4 ea)	90-Start up Operation	50135674-1
MS27151-7	Pal Nut	8 Ea (8 ea)	90-Start up Operation	5089299
NAS1149D0463J	Washer	8 Ea (8 ea)	90-Start up Operation	5067901
NAS1149F0563P	Washer	4 Ea (4 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-12A	8	147	0
	D5350-041	1	3	0
	D5350-043	1	0	0
	D5352-1	4	88	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval _____		
Description Work Order Deviation				Disposition					
Root Cause				FAULT CATEGORY					
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Potential	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Fold	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grinding	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Weld	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Oil	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____					
Misidentified	☐	Past Due	☐						

Inspector: _____
 Supervisor: _____
 Job No: 180702
 Serial No/Batch: S116263
 Part: D066-1016-115
 Container No: S116263
 Barcode:
 DART Aerospace Ltd.
 1270 Aberdeen Street
 Hemetbury, ON K6A 1K7
 CANADA
 TEL: 1 813 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com
 Instructions: TC STC SH17-7 - Issue Date: FMS/STC SR03917NY 17/05/31

D5354-041	1	4	0
D5354-042	1	4	0
D5355-041	2	0	0
D5358-1	2	8	0
D5445-041	1	1	0
D5445-042	1	2	0
MS20392-4C57	4	18	0
MS24665-229	4	137	0
MS27151-7	8	10	0
NAS1149D0463J	8	7,036	0
NAS1149F0563P	4	590	0

Part Specifications

Specifications could not be found.

Plex 7/12/18 7:41 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

5.0 PARTS LIST

Qty -011	Qty -012	Qty -111	Qty -113	Qty -115	Qty -121	Qty -123	Part Number	Description
X							D066-1016-011	R66 QR HELI-UTILITY-BASKET, LH
	X						D066-1016-012	R66 QR HELI-UTILITY-BASKET, RH
		X					D066-1016-111	CROSSTUBE CLAMP KIT
			X				D066-1016-113	CROSSTUBE CLAMP + LONGITUDINAL BEAM KIT
1	1			X			D066-1016-115	BASKET MOUNTING PROVISIONS KIT
					X		D066-1016-121	FWD LID GAS SPRING UPGRADE (OPTIONAL)
						X	D066-1016-123	FWD FIXED STEP UPGRADE (OPTIONAL)
1							D5337-011	BASKET ASSEMBLY, LH
	1						D5337-012	BASKET ASSEMBLY, RH
					2		D3953-17	GAS SPRING SPACER
					1		D3953-19	GAS SPRING BRACKET
					1		D3953-21	GAS SPRING BRACKET
					2		D3953-3	GAS SPRING STUD
					2		D3953-7	GAS SPRING SPACER
					2		D3953-9	GAS SPRING WASHER
					1		D3969-7	GAS SPRING
				1			D5350-041	R66 FWD CROSS BEAM ASSEMBLY
				1			D5350-043	R66 AFT CROSS BEAM ASSEMBLY
		4	4	4			D5352-1	CUSHION
		1	1	1			D5354-041	R66 FWD CLAMP ASSEMBLY, LH
		1	1	1			D5354-042	R66 FWD CLAMP ASSEMBLY, RH
		2	2	2			D5355-041	R66 AFT CLAMP ASSEMBLY
1	1						D5357-041	STRUT ASSEMBLY
		2	2	2			D5358-1	COVER PLATE
			1	1			D5445-041	LONGITUDINAL BEAM ASSEMBLY, LH
			1	1			D5445-042	LONGITUDINAL BEAM ASSEMBLY, RH
						1	D5510-041	FWD STEP
					2		AN310C4	NUT, CASTELLATED
					4		AN3-14A	BOLT
			8	8			AN4-12A	BOLT
						2	AN4-14A	BOLT
				4			MS20392-4C57	PIN
					4		MS21042L3	NUT
						2	MS21042L4	NUT
				4			MS24665-229	COTTER PIN
					2		MS24665-300	COTTER PIN
		8	8	8			MS27151-7	STAMPED NUT
					2		NAS1149C0432R	WASHER
			8	8		4	NAS1149D0463J	WASHER
				4			NAS1149F0563P	WASHER
					8		NAS1149F0332P	WASHER